

Work Order ID 84740-1

Tuesday, May 22, 2012 1:05:32 PM

*Split*

\*84740\*

*Ship Friday* Page 1

Item ID: D212-725-1-929

Revision ID:

Item Name: HOUSING ASS'Y

Start Date: 5/22/2012 Start Qty: 10.00

Required Date: 5/25/2012 Req'd Qty: 10.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D212-725-1

Rev F

100

\*100\*

Purchasing

Purchasing

Memo

Issue P/O:

E-mail or Ship electronic file and or dwg to vendor to  
manufacture the following:  
qty 1 D212-725-1-147

Manufacture as per Dwg and supplied files  
Possible supplier: Sieg's  
Material release note is required

0.00

0.00

*N/A*  
*see w/o*  
*52709*  
*PO/w/o was*  
*MF*  
*12-05-22*  
*costed at 0.*

110

\*110\*

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

*A*

*was already*  
*inspected on*  
*w/052709*  
*MF*  
*12-05-22*  
*free attached*



# Work Order ID 84740

Tuesday, May 22, 2012 1:05:32 PM

\*84740\*

Page 2

Item ID: D212-725-1-929

Revision ID:

Item Name: HOUSING ASS'Y

Start Date: 5/22/2012 Start Qty: 10.00

Required Date: 5/25/2012 Req'd Qty: 10.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

120

\*120\*

QC

Quality Control

Operation  
Description

QC6- Inspect dimensions to drawing

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

\*130\*

Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: 114509

0.00

Memo

0.00

⑥

0 125-23 pto

140

\*140\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⑤

nl 12-05-23





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-5-23	130	part was scrapped taking it out of sig		Scrap + Destroy qty x1 No Replace - Apply Anisize to help remove part from sig	EZ 12-5-23	n/ 12-05-23		

NOTE: Date & initial all entries





# Work Order ID 84740

Tuesday, May 22, 2012 1:05:32 PM

**\*84740\***

Page 3

Item ID: D212-725-1-929

Revision ID:

Item Name: HOUSING ASS'Y

Start Date: 5/22/2012 Start Qty: 10.00

Required Date: 5/25/2012 Req'd Qty: 10.00

Reference:

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*150\***

QC

Quality Control

Memo

0.00

6x

CP 12.05.23

160

Identify as per dwg & Stock Location: 38

0.00

**\*160\***

Packaging

Packaging

Memo

0.00

50

12/5/28

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Quality Control

Memo

0.00

ML 12/5/28







# Picklist Print

Tuesday, May 22, 2012 1:05:31 PM

Page 1

Work Order ID: 84740

Parent Item: D212-725-1-929

Parent Item Name: HOUSING ASSY

Start Date: 5/22/2012

Required Date: 5/25/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A08-03-11New IssueDD verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D212-725-1-143

Base Plate

Manufactured

No

Each 4.0000

52702 MF 12-05-22

Location

ST367

Loc Qty

4

Loc Code

52702

4

D212-725-1-145

Tube

Manufactured

No

Each 10.0000

10

Location

ST366

Loc Qty

10

Loc Code

52705

10

D212-725-1-147P

Cup

Purchased

No

Each 0.0000

10

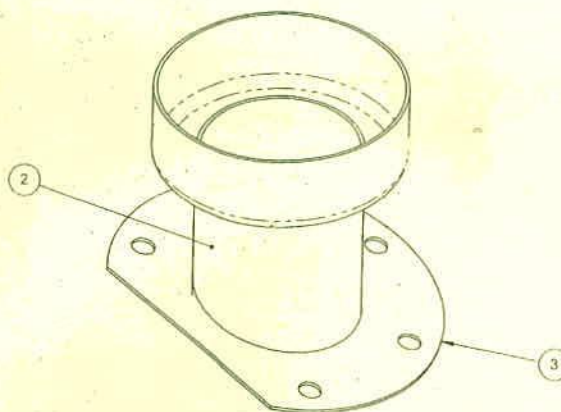
MF 12-05-22

52709 MF 12-05-22





ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D212-725-1-929	HOUSING ASSEMBLY
2	1	D212-725-1-145	TUBING
3	1	D212-725-1-143	BASE PLATE
4	1	D212-725-1-147	CUP



**D212-725-1-929 HOUSING ASSEMBLY**

**NOTES:**

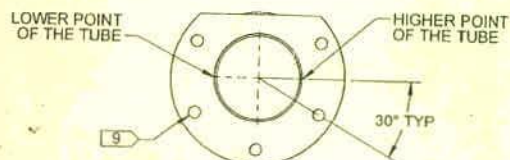
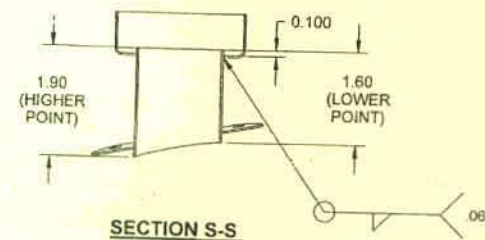
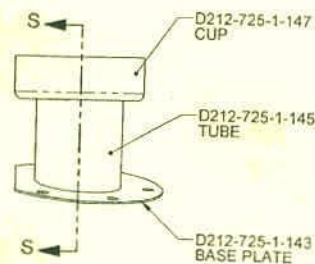
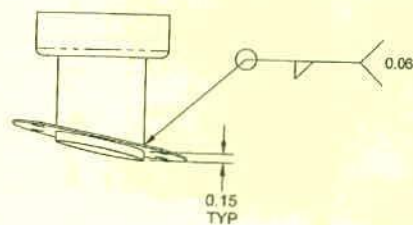
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.19 lbs

**RELEASED**  
2011-08-25  
*W*

A		NEW ISSUE		RF	11.02.24
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A		
MFG. APPR.	<i>[Signature]</i>	D4238	SHEET 1 OF 5		
APPROVED	<i>[Signature]</i>	TITLE	SCALE		
DE APPR.	<i>[Signature]</i>	HOUSING ASSEMBLY	NTS		
DATE	11.02.24		<small>           COPYRIGHT © 2011 BY DART AEROSPACE LTD            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS            NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED FOR ANY OTHER PERSON WITHOUT            WRITTEN PERMISSION FROM DART AEROSPACE LTD.         </small>		







# D212-725-1-929 HOUSING ASSEMBLY

RELEASED  
2011-08-25  
JW

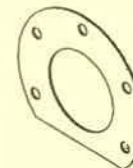
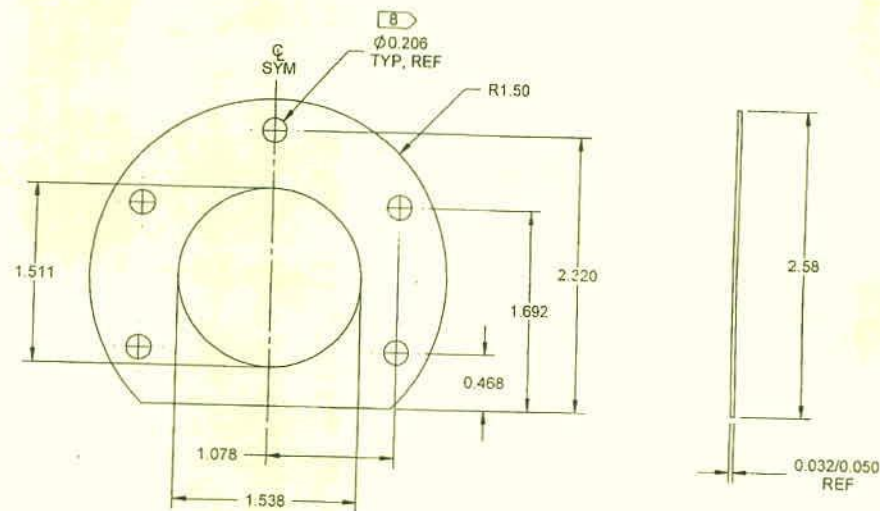
## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.19 lbs
- 8) WELD PER DART QSI 004
- 9) TYPICAL. HOLES ARE TRANSFER FROM AIRCRAFT

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4238</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE <b>HOUSING ASSEMBLY</b>	SHEET 2 OF 5
DE APPR.	<i>[Signature]</i>	SCALE N/A	
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#### NOTES:

- 1) MATERIAL: AISI 301 STAINLESS STEEL 1/4 HARD SHEET, 0.032/0.050 (22/18 GAUGE) THICK  
PER AMS 5517  
OR AMS 5518  
OR AMS 5902  
OR AMS 5519  
OR ASTM A666 WITH MIN. F<sub>tu</sub> = 125 Ksi & MIN. F<sub>ty</sub> = 75 Ksi  
REF DART SPEC. M301S22GA OR M301S18GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs
- 8) DIMENSIONS BETWEEN HOLES ARE PROVIDED FOR REFERENCE ONLY.  
TRANSFER Ø 0.206 HOLES FROM AIRCRAFT

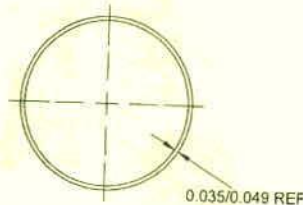
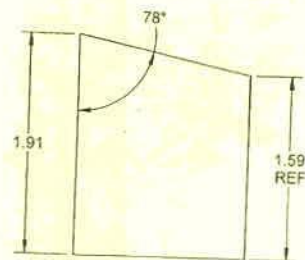
**D212-725-1-143 BASE PLATE**

LEASED  
2011-08-25

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4238	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR		HOUSING ASSEMBLY	NTS
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D212-725-1-145 TUBING

**NOTES:**

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL, Ø 1.500 x 0.049/0.035 WALL  
PER ASTM A213 OR ASME SA213 OR ASTM A269  
REF DART SPEC. M304TR1.500W.049 OR M304TR1.500W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4238	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	HOUSING ASSEMBLY	N°S
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RELEASED  
2011-08-25  
*[Signature]*





OPEN TO  
Ø 1.503  
AS SHOWN

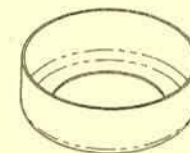
Ø 2.25  
REF

0.032  
REF

R0.13  
REF

0.75  
REF

D212-725-1-147 CUP



NOTES:

- 1) MATERIAL: STAINLESS STEEL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs
- 8) POSSIBLE SUPPLIER: BELL P/N 204-060-767-001 OR 204-060-741-001

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO D4238	REV. A
MFG. APPR	<i>[Signature]</i>	TITLE	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	HOUSING ASSEMBLY	SCALE
DE APPR.	<i>[Signature]</i>		NTS
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# Work Order ID 52709

October 8, 2009 10:24:37 AM

REFERENCE ONLY

Page 1

Item ID: D212-725-1-929

Revision ID: B

Item Name: HOUSING ASS'Y

Start Date: 10/08/09 Start Qty: 10.00

Required Date: 10/23/09 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

QC:

Date: 10/10/09 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw Draw Plan Accept Reject Reject Insp.  
Number Rev. Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D212-725-1

Rev B

100

0.00

Purchasing

Memo

0.00

Purchasing

Issue P/O: W. J. K.  
E-mail or Ship electronic file and or dwg to vendor to  
manufacture the following:  
qty 10 D212-725-1-147

Manufacture as per Dwg and supplied files  
Possible supplier: Sieg's  
Material release note is required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

*10/10/09 (10)*  
*10/12/09 (10)*





# Work Order ID 52709

October 8, 2009 10:24:37 AM



Page 2

Item ID: D212-725-1-929

Accept



Setup Start



Revision ID: B

Item Name: HOUSING ASS'Y

Stop



Start Date: 10/08/09 Start Qty: 10.00



Cust Item ID:

Required Date: 10/23/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

130

Weld per dwg A/R S.S. rod Batch

0.00



Large Fab

Memo

0.00

Large Fab

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/27

x 16

10-3-18 SP (10X)





# Work Order Summary

Tuesday, May 22, 2012 12:55:52 PM

Page 1 of 1

Criteria : Work Order ID: 52709 Item ID: D212-725-1-929RevB Product Family PURCHASED ITEMS  
 Work Order Start Dates 10/8/2009 to 10/8/2009 11:59:59 PM Work Order Required Dates 10/23/2009 to 10/23/2009 11:59:59 PM  
 All References  
 Work Order Status Costed

Work Order ID 52709 Required Qty 10.0000 Status Code Costed  
 Item ID D212-725-1-929RevB Accepted Qty 0.0000 Scrap Qty 0.0000  
 Item Name HOUSING ASS'Y  
 Current Acct Value \$57.280

Start Date 10/8/2009 Required Date 10/23/2009 Completed Date 11/3/2011 8:38:25 AM

Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each	Each
Material	\$213.050	\$0.000	\$57.280	\$57.280	100.00%
Labor	\$167.728	\$0.000	\$0.000	\$0.000	0.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$628.710	\$0.000	\$0.000	\$0.000	0.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$1,009.487	\$0.000	\$57.280	\$57.280	0.00%

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
D212-725-1-143 Base Plate	10.0000		3/22/2010	10.0000	\$118.579
D212-725-1-145 Tube	10.0000		3/22/2010	10.0000	\$710.079
D212-725-1-147P Cup	10.0000		2/26/2010	10.0000	\$155.000
Total Matl Amts:					\$983.658

## Work Center Large Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
EWER01												
	10/13/2009											
130			0.00	0.00	0.00	0.00	1.00	\$0.000	\$0.000	\$0.000	\$0.000	\$0.000
	1/28/2010											
130			0.00	0.00	0.01	0.01	1.00	\$0.000	\$0.169	\$0.336	\$0.000	\$0.504
	4/27/2010											
130			0.00	0.00	0.50	0.50	1.00	\$0.000	\$10.130	\$15.195	\$0.000	\$25.325
Total:			0.00	0.00	0.51	0.51	3.00	\$0.000	\$10.299	\$15.531	\$0.000	\$25.829

Tuesday, May 22, 2012 12:55:52 PM

Work Order Summary

Page 1 of 1





